














Tap M12 Z3

A10-020

The geminiTAP machine is equipped with 2 grinding spindles, 2 dressing units an oscillating table (W-axis) and a 6-axis robot. In the production cycle the dressing cycles are included. It is not needed to dress the flute wheel during every cycle, therefore we can reduce the cycle time by around 10 seconds.



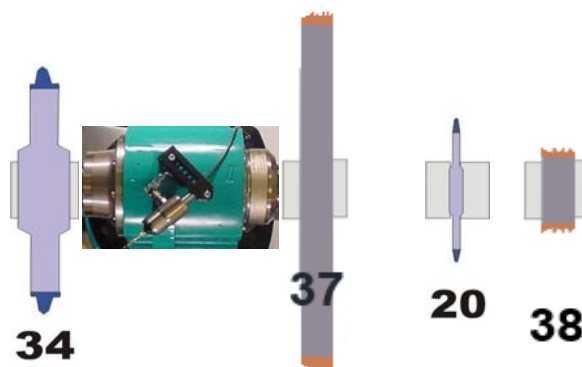
1. Cycletime for Production

Tool specifications							
M12, Length 24 mm, flutelength 40 mm, Helix 0°							
Material HSS							
Operations							
Load							
Feed [mm/Min]		2000	12000	12000	12000	100	100
Power [kW]		6	4	4	4	1	1
Cutting feed [m/s]		70	65	65	65	24	24
Used wheels							
Grinding time [s]	14	25	25	19	21	16	32
Total cycle time	2 Min 32						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø180 DXF A80
 37 Ø400 1A1 A250
 20 Ø125 14EE1 D301
 38 Ø90 DXF D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : geminiTAP, dressing unit
 Control: Fanuc 31i B5
 Coolant: Synthetic Oil, pressure 14-16 bar
 Software: Quinto 5

responsible engineer: FFR,16.01.14

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